

Date: Friday, 07/03/2008 10:41:04 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 FLOAT SKIDTUBE  
Job Number : 37688  
Estimate Number : 11437  
P.O. Number :  
This Issue : 07/03/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : LANDING GEAR  
Previous Run : 37687  
Written By : J-L Menard 08.03.07  
Checked & Approved By :  
Comment :  
est rev A 05.12.13 New issue EC  
est rev B 06.02.09 Dwg @ revD EC  
est rev C 07.03.13 dwg @ revF ec  
est rev D 07.10.31 ecn 1053P EC  
Est Rev:E ECN 1056 07-11-13 DD verified by: EC

Part Number : D3391015  
Drawing Number : D3391 REV G  
Project Number : N/A  
Drawing Revision : G  
Material :  
Due Date : 14/03/2008 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0

D6014090

ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 0832309

Identify as D3391-3

J-F. 08/03/09 ①

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: 44 &amp; Dwg D3391 Rev: G

J-F. 08/03/09 ①

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 08/03/09 ①

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

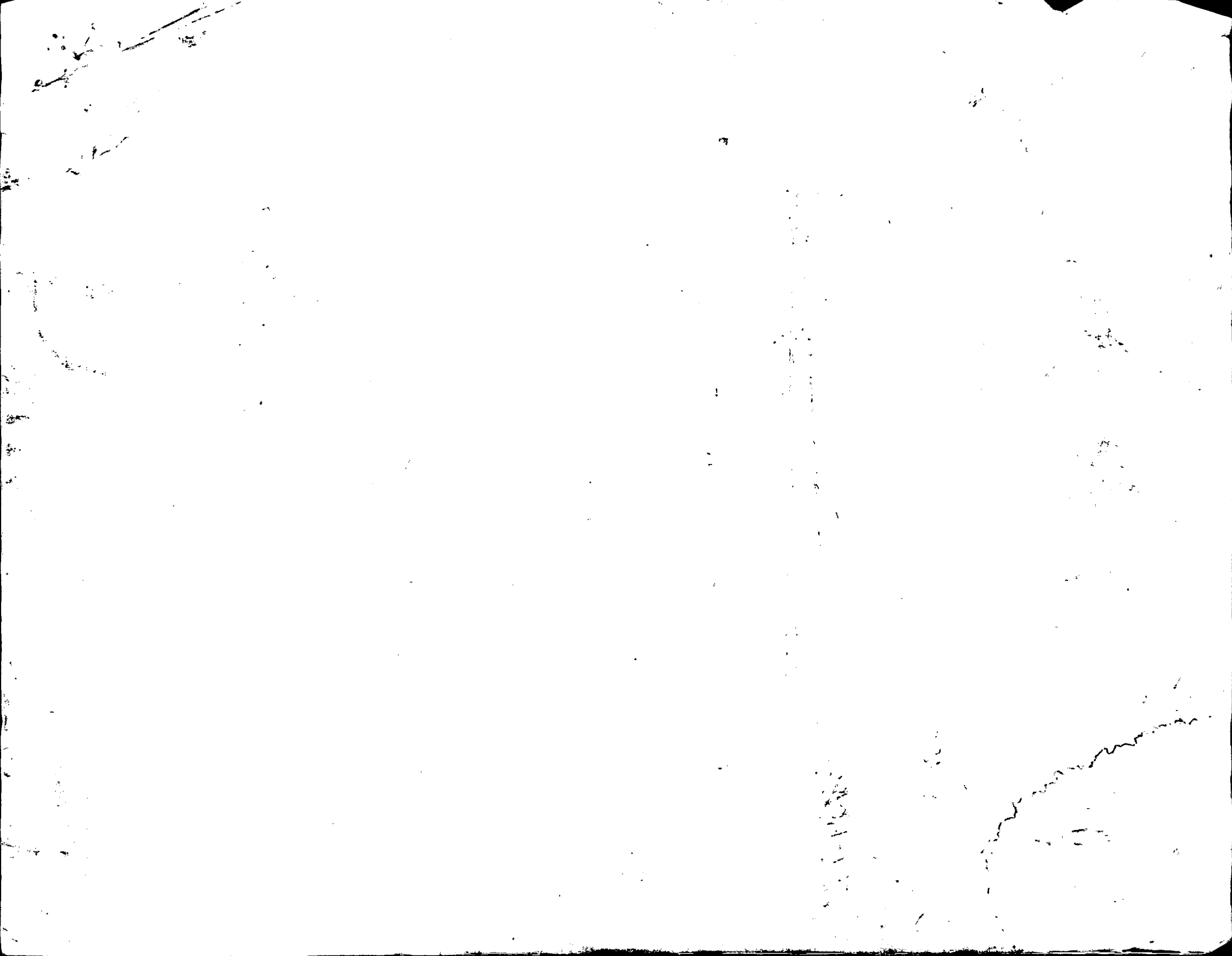


Comment: HAAS

1-Machine as per Folio FA 599 Rev: 44 &amp; Dwg D3391 Rev: G

2-Debur

J.L. 08/07/31



Date: Friday, 07/03/2008 10:41:04 AM  
User: + Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/07/31

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SF 08/08/01

7.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0 BENDING BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391

DP 8-8-5

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/05 (20)

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8808 (ALL HOLES)

3-Drill and c' sink wearshoe holes as per Dwg D3391

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391  
Deburr

5- Tranfer holes from D3391-013 for electric step in tube

VH  
8-8-7

11.0 QC5 INSPECT WORK TO CURRENT STEP

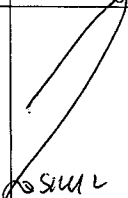
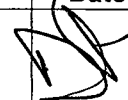


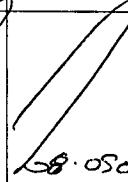


Comment: INSPECT WORK TO CURRENT STEP

S 08/09/07 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-015 PAR #: N/A Fault Category: Prod / Skid tube NCR: (Yes) No DQA: L Date: 09/04/09  
 Resolution: D412-742-041 N/A Disposition: N/A QA: N/C Closed: D Date: 09/04/09

NCR: <u>37688</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.09.01	10.0	open ASS-y tube holes CC-CC do not line up, with the mid-tube. tube is scrap. R.C. process.		Scrap & destroy no replace.	 9-4-7			

NOTE: Date & initial all entries

Date: Friday, 07/03/2008 10:41:04 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

DP 8-8-18

13.0 036704200 SPACER



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
SPACER  
Batch: 036704200 8-8-18 (14)

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
1-Install crossbolt spacers per dwg D3391

A/R Magnabond 6398 batch: M107621 Exp. 9-8-1

M 8-8-18

2- Grind flush

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (40)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M108523

M 08/08/25

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-26 (KU)

18.0 02646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Batch: 02646 8-8-18

M 08-08-26 (KU)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #: Machine Or Operation: Description :

19.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: ~~038947~~ *94*

20.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

Batch: ~~033869~~ *906*

21.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: ~~032440~~ *98*

22.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: ~~033870~~ *94*

23.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

Batch: ~~039275~~ *94*

24.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

Batch: ~~0405819~~ *94*

or equivalent per

QSI 017

25.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

Batch: ~~04100184~~ *94*

08-08-06

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent  
per QSI 017

26.0

~~AN34428165~~

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inserts

Batch: ~~1108599~~ *96*

27.0

~~AN3C4A~~

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: ~~1108599~~ *96*

28.0

~~AN3C5A~~

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: ~~1108748~~ *96*

29.0

~~AN960C10L~~

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: ~~1108618~~ *96*

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: *✓* SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts per dwg D3391

2-Install Aft Cap as per Dwg D3391

*✓* A/R Sikaflex-241-291 *M108801*

Sikaflex expiry date: *08/10*

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Date: Friday, 07/03/2008 10:41:05 AM  
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Job Number: 37688

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
09-04-07



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 37688
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> G	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

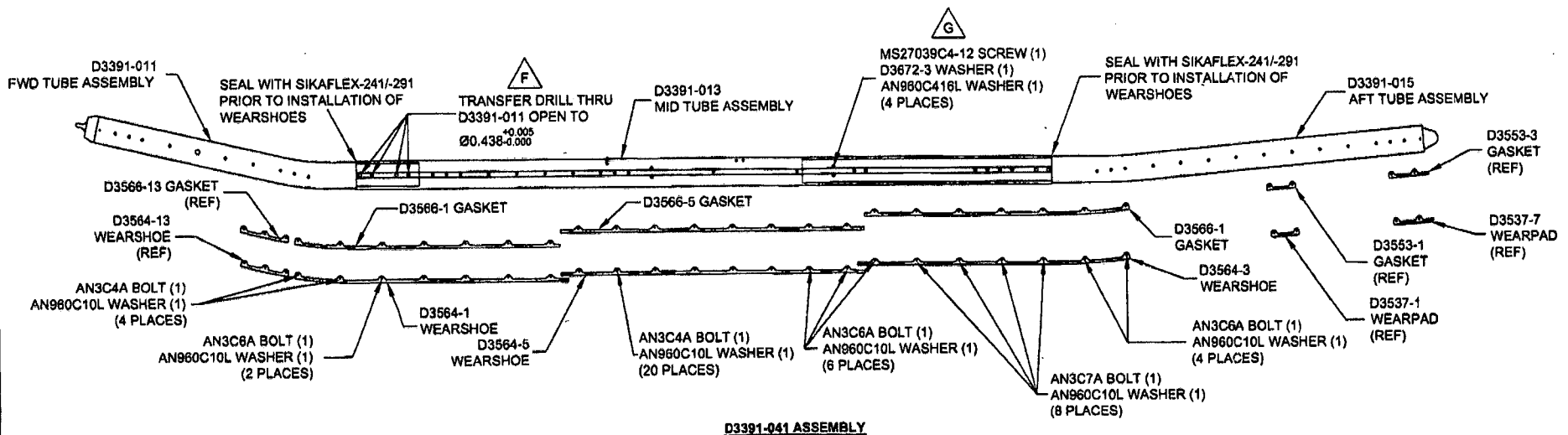
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000"	✓			
3.500	+/-0.010	3.504"	✓			
88.93	+/-0.030	88.930"	✓			
44.995	+/-0.030	45.00	✓			
3.200	+/-0.010	3.204	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	.201	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.296	✓			
0.200	+/-0.010	.202	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

<b>Measured by:</b> J.F./J.L.	<b>Audited by:</b> SF	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08/03/09	<b>Date:</b> 08/08/01	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	



c/o 37688.



**D3391-041 ASSEMBLY**

RELEASED  
07-11-87

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

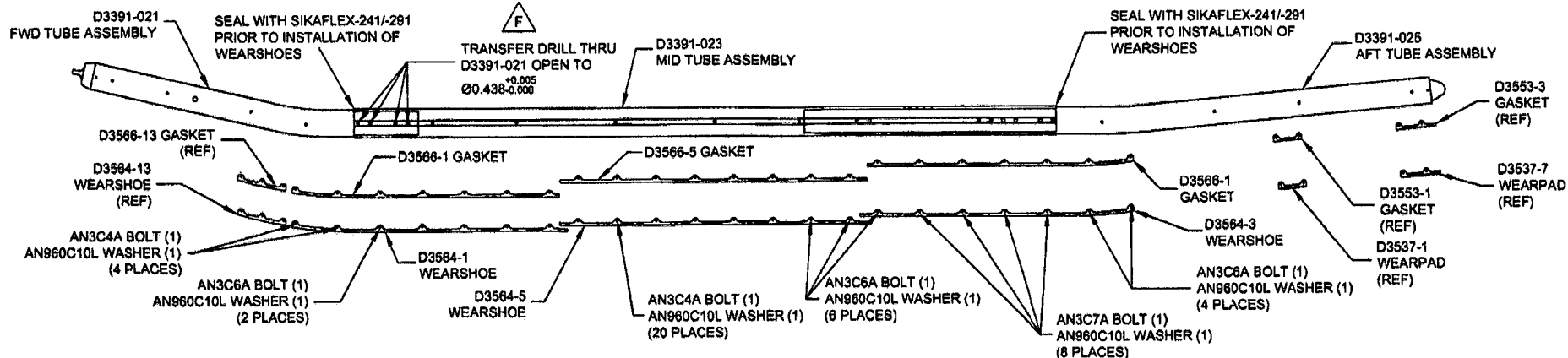
QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
4	AN980C10L	WASHER
4	MS27039C4-12	SCREW
4	AN980C416L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.08.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JPE		
CHECKED	JPE		
MFG. APPR.	JPE		
APPROVED	JPE		
DE APPR.	JPE		
DATE	07.07.31		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D3391  
REV. G  
SHEET 1 OF 8  
TITLE 412 FLOAT SKIDTUBE  
SCALE NTS  
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#### D3391-043 ASSEMBLY

RELEASED  
07.11.94

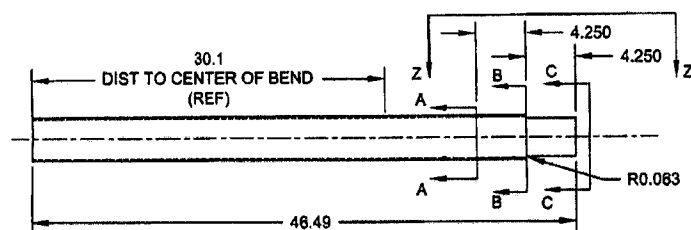
#### D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
24	AN960C10L	WASHER

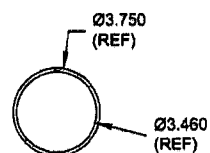
#### GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

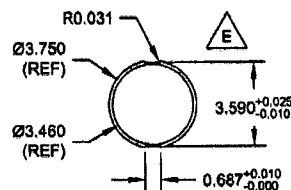
DESIGN	TH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. G
MFG. APPR.	h	D3391	SHEET 2 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



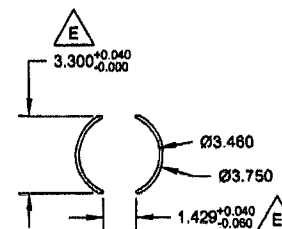
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



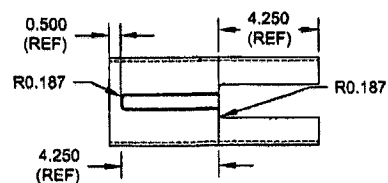
**SECTION A-A**  
(SCALE 1:5)



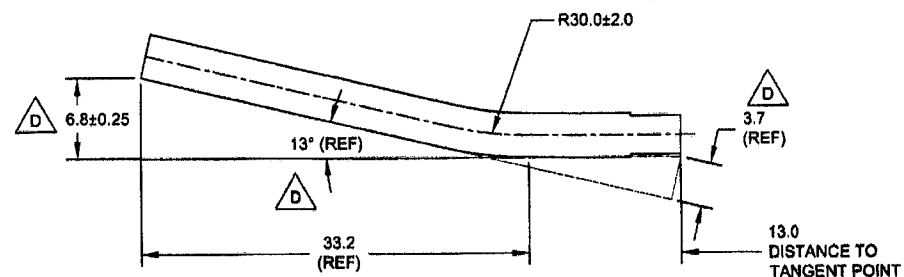
**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



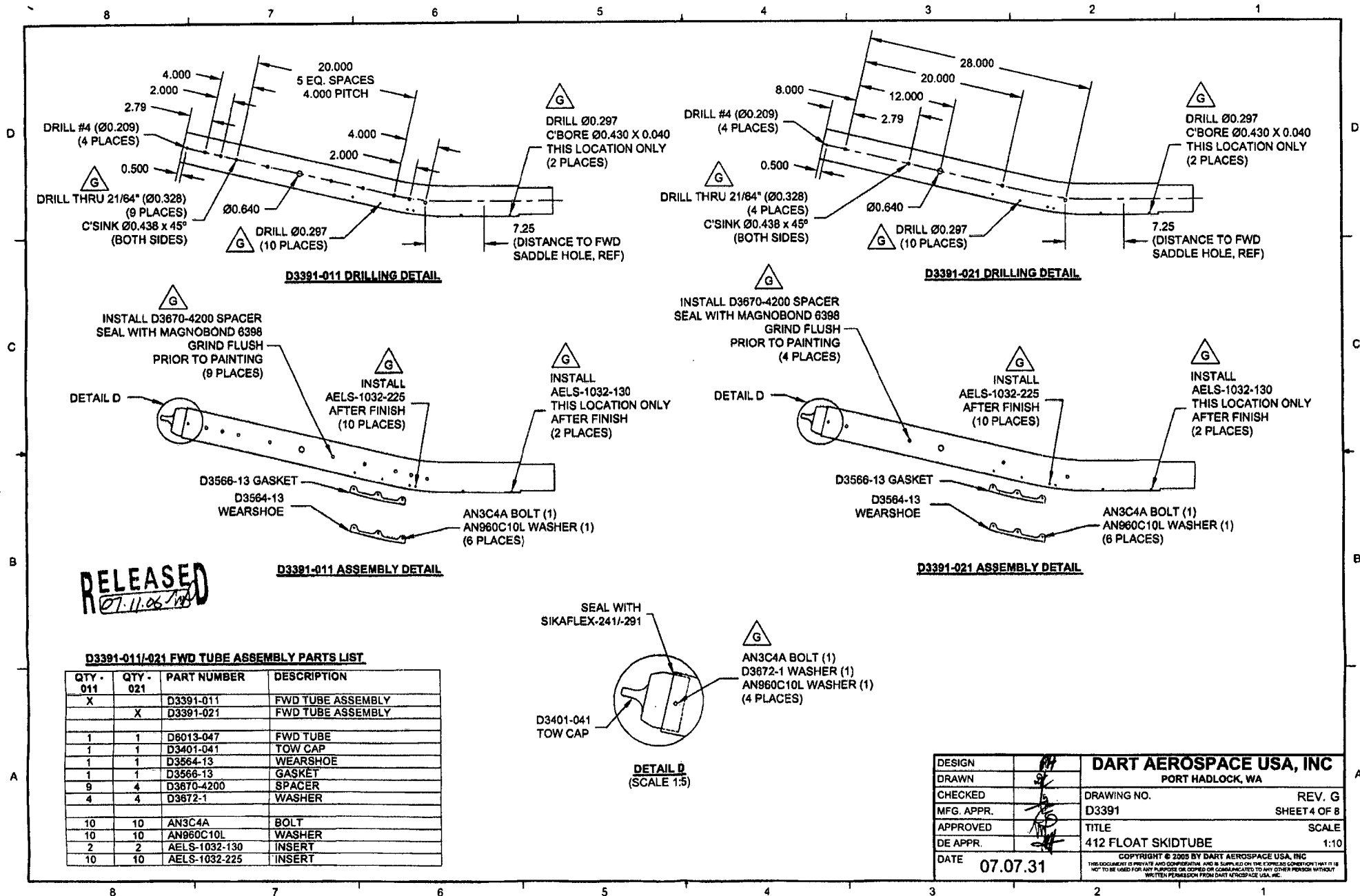
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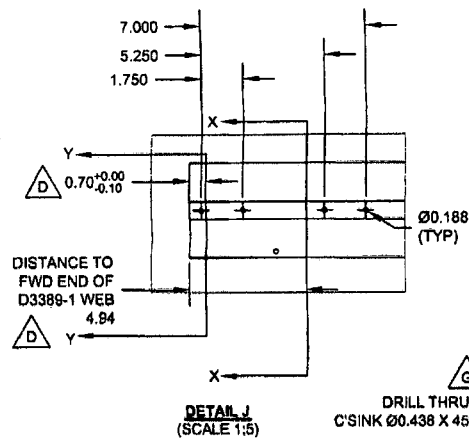


**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)

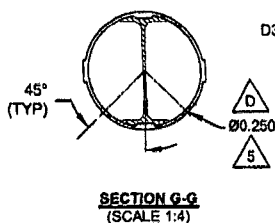
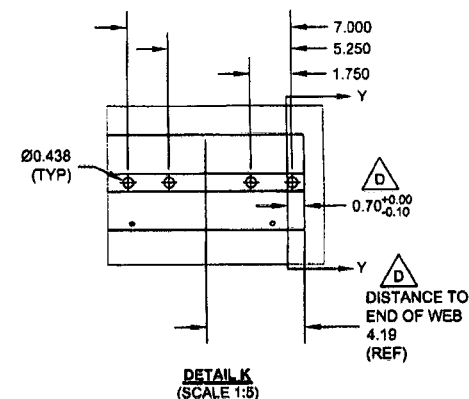
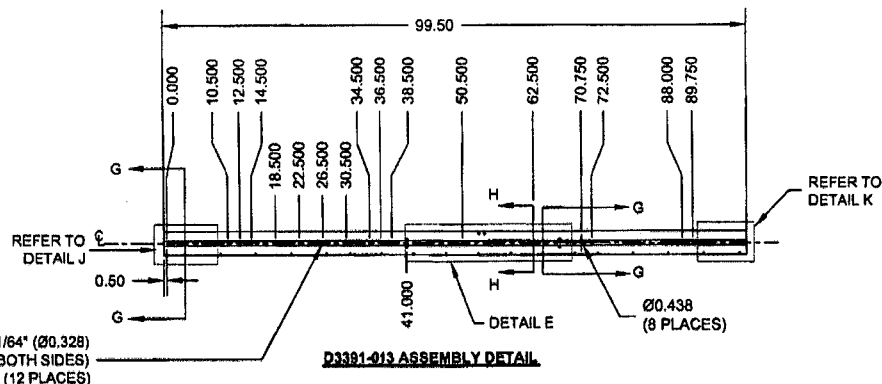
RELEASED  
07-11-08

DESIGN	01	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SLC	PORT HADLOCK, WA	
CHECKED	SLC	DRAWING NO. D3391	REV. G
MFG. APPR.	SLC	SHEET 3 OF 8	
APPROVED	SLC	TITLE	SCALE
DE APPR.	SLC	412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

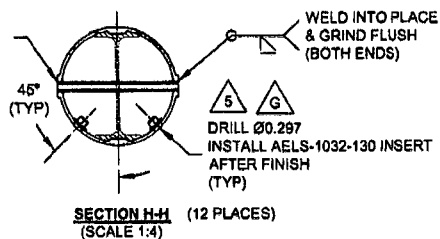




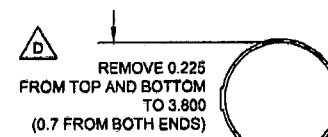
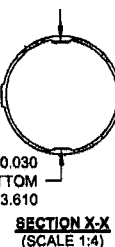
DRILL THRU 21/64" (Ø0.328)  
C/SINK Ø0.438 X 45° (BOTH SIDES)  
(12 PLACES)



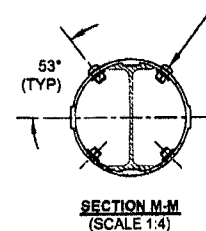
INSTALL  
D3681-1 SPACER



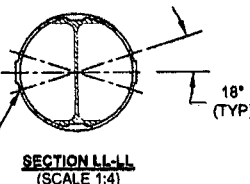
REMOVE 0.030  
FROM TOP AND BOTTOM  
TO 3.610



DRILL Ø0.297  
INSTALL AELS-1032-130 INSERT  
MS27039C1-09 SCREW  
D3672-1 WASHER  
AN960C10L WASHER  
AFTER FINISH  
(TYP 4 PLACES)



DRILL Ø0.250  
(TYP 4 PLACES)



# **D3391-013 MID TUBE ASSEMBLY PARTS LIST**

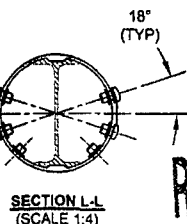
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

## **D3391-013 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- WELDING: PER DART QSI 004

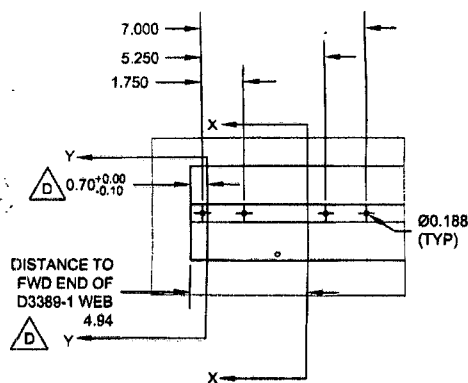
DRILL Ø0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
(TYP 4 PLACES)

**DETAIL E**  
(SCALE 1:8)

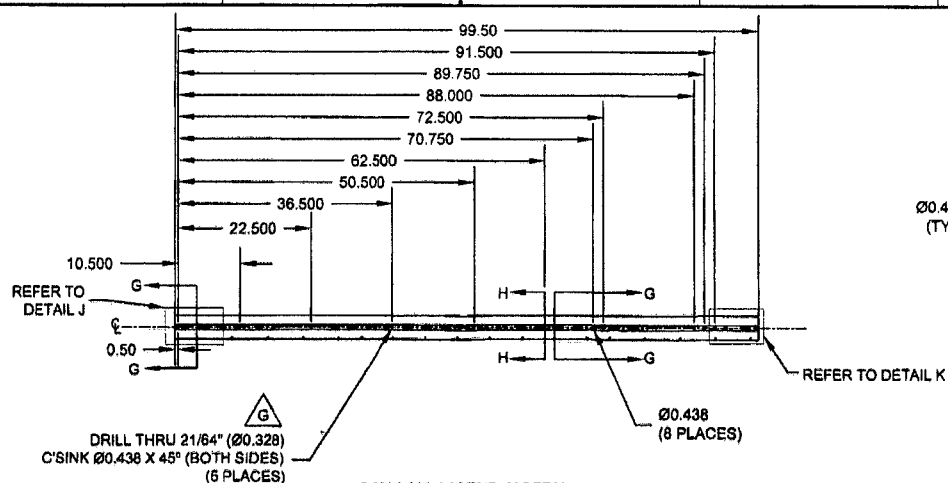


**RELEASED**  
07-11-06

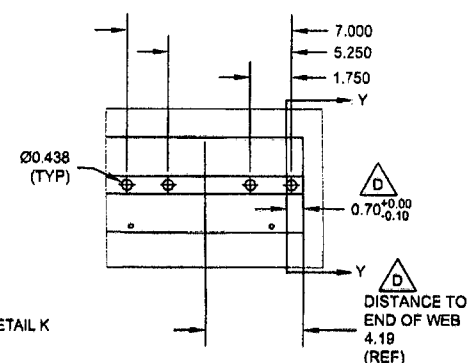
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	DP	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D3391 SHEET 5 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE 1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC



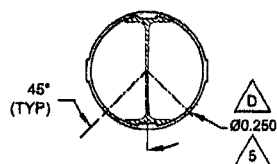
**DETAIL J**  
(SCALE 1:5)



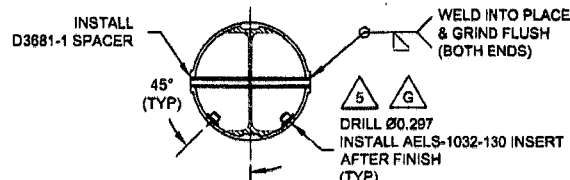
**D3391-023 ASSEMBLY DETAIL**



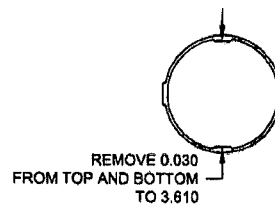
**DETAIL K**  
(SCALE 1:5)



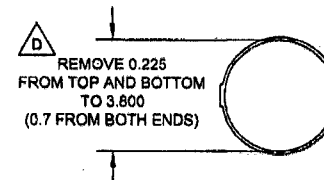
**SECTION G-G**  
(SCALE 1:4)



**SECTION H-H**  
(SCALE 1:4)



**SECTION X-X**  
(SCALE 1:4)



**SECTION Y-Y**  
(SCALE 1:4)

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3881-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

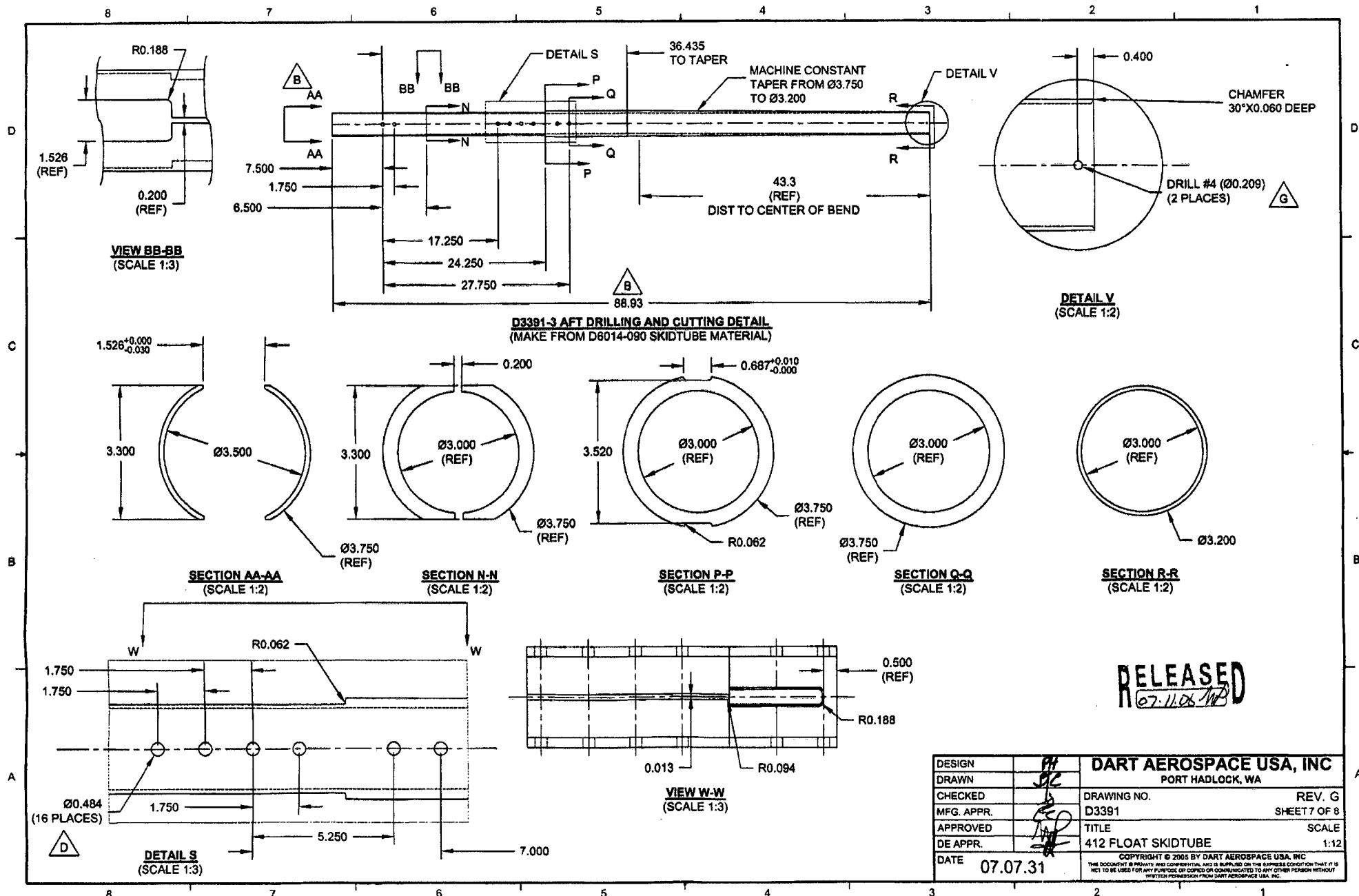
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

**RELEASED**  
07.11.06/11

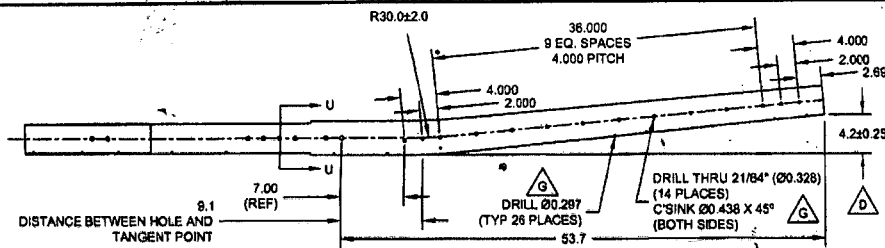
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	DE	PORT HADLOCK, WA
CHECKED	LS	DRAWING NO. D3391
MFG. APPR.	PH	REV. G
APPROVED	PH	SHEET 6 OF 8
DE APPR.	PH	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE 1:20

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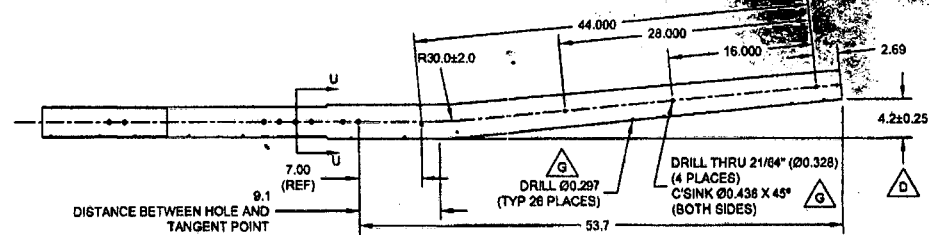






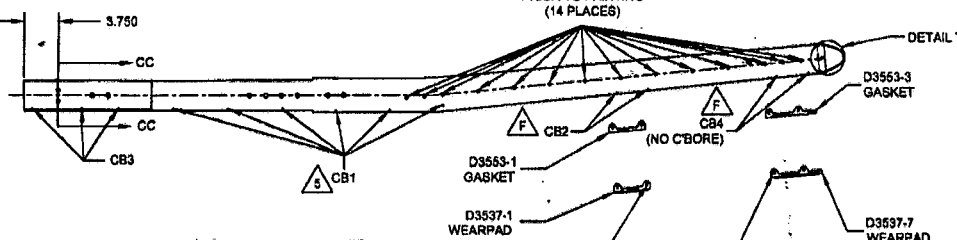
**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(14 PLACES)

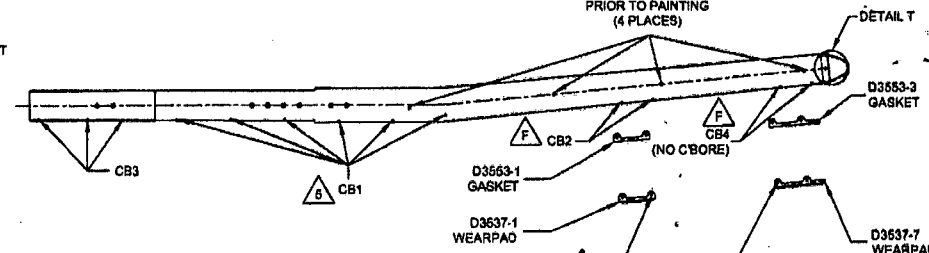


**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
(4 PLACES)



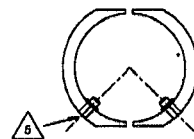
**D3391-015 ASSEMBLY AND C'BORE DETAIL**  
(SEE TABLE)



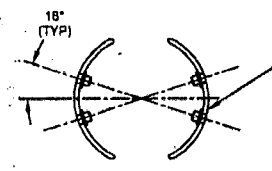
**D3391-025 ASSEMBLY AND C'BORE DETAIL**  
(SEE TABLE)

**D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D8014-090	AFT TUBE
1	1	D2648	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-1	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

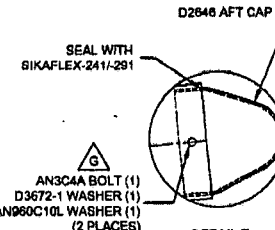


**SECTION U-U**  
(SCALE 1:3)



**SECTION CC-CC**  
(SCALE 1:3)

DRILL 0.391  
C'BORE 0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT (1)  
(4 PLACES)



**DETAIL T**  
(SCALE 1:3)

**RELEASED**  
07.11.06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	0.430 X 0.170	AELS-1032-225
CB2	4	4	0.430 X 0.170	AELS-1032-130
CB3	6	6	0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
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CHECKED	S	DRAWING NO. REV. G
MFG. APPR.	11	D3391 SHEET 8 OF 8
APPROVED	11	TITLE SCALE
DE APPR.	11	412 FLOAT SKIDTUBE 1:12
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